

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006950**Date Inspected:** 26-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG superstructure trial assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG superstructure trial assembly east line

This QA observed the contractors personnel performing a variety of tasks relative to the fabrication of the OBG east line including the following: install and drill side and bottom panel T-stiffener splice plates, general clean up and grinding, trimming stock material off of 2AE where crossbeam CB1 will connect and removing temporary fit up lugs from OBG splice between OBG 4BE and 5AE.

OBG superstructure trial assembly west line

This QA observed ZPMC qualified welding personnel identified as 068251 perform SMAW repair welding on rain diverters at various locations on the west line. ZPMC QC identified as Mr. Zhang Zheng Mao was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair.

This QA observed ABF inspector checking root openings at the segment splice between 5AW and 4BW. The root openings inspected while this QA was present appeared to comply with the contract documents.

ZPMC QC identified as Mr. Zhang Zheng Mao informed this QA that the welding at OBG segment splice

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between 2AW and 2BW is complete.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

As mentioned above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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**Inspected By:** Hall,Steven

Quality Assurance Inspector

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**Reviewed By:** Prue,Erik

QA Reviewer